

WORK ORDER 2012-26

Date opened: 26 June 2012

Project: Quick Release XL Cargo Basket Assembly
Type: Bell 206L Series, 407Batch Quantity: 2 Complete Basket Assembly (94510-01)
2 with Front End Cutout (70411)
2 with Lid Step (70405)Approval: SH00-48
Drawing List: DCL945-10, DCL704

Fabrication and Assembly Drawing(s)	Description
94510, Rev. 0	Basket Ass'y
94511, Rev. 0	Basket Body Ass'y
69812, Rev. 3	Basket Lid Ass'y
84255, Rev. 1	Handle Installation
84261, Rev. 1	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y
70405, Rev. 3	Lid Step Modification
70411, Rev. 0	Front End Cutout Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	Y
Document Control List revision level matches (or exceeds) STC:	Y
Drawings revision levels match Document Control List:	Y
Purchase order or Work order source is recorded for each part/ass'y:	Y
Tests and inspections specifically called out on drawings are complete:	Y
Release tags associated with all fabricated parts are attached:	Y
All mounting hardware and supplies are included:	Y

List all non-conformities raised: _____

Welder Signature: _____ Date: _____

Inspector Signature: _____ Date: _____

Drawing: 94510 Revision 0
 Assembly: 94510-01 Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	94510-01	Cargo Basket Assembly			
. 1	94511-01	Basket Body Assembly	Below		
. 1	69812-01	Basket Lid Assembly	Below		
. 1	84255-01	Handle Bar Installation	Below		
. 1	36280-01	Brace Assembly	9-2081 Brace	12059	
. 1	MS20001P4	Piano Hinge			
. 1	69827-01	Placard	0.050" Sheet, 6061-T6 Aluminum	11/102	
. 3	49205-14	Bumper	Argus Industries Bumper		
. 22	CR3213-5-02	Blind Rivet			
. 8	CR3523-5-02	Monel Blind Rivet			
. 4	CR3213-4-02	Blind Rivet			
. 4	40088-14	Fitting	Ancra	W02012-44	
. 4	AN960-616	Washer (NAS1149F0663P)			
. 1	AN3-15A	Bolt			
. 1	AN3-17A	Bolt			
. 4	AN960-10	Washer (NAS1149F0363P)			
. 2	AN970-3	Washer			
. 2	MS21044N3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-5-02, CR3523-5-02 Rivets, CR3213-4-02		
Final Inspection	Drawing 94510			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **94511** Revision 0
 Assembly: **94511-01** **Basket Body Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
2 Total	94511-01	Basket Body Assembly			
. A/R	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube	12045	
. 3	94520-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. 1	94521-01	Forward Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. 1	94522-01	Aft Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. 4	69823-02	Lug	1018 Mild Steel, 5/8" Rod	12056	
. 1	84262-01	Handle Bracket Assembly	Below		
. 1	49215-01	Spacer	1018 Steel, 1/2" Rod	12056	
. A/R	3/4-16F	Mesh	Expanded carbon steel	12045 + 10112	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 94511	PO 12088 + PO 12090 -		
Final Inspection	Drawing 94511			

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Drawing: **69812** Revision **3**
 Assembly: **69812-01** **Basket Lid Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	69812-01	Basket Lid Assembly			
. 2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	12045	
. 2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube	12045	
. 3	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube	12045	
. 1	49216-01	Spacer	1018 Steel, 1/2" Rod	12056	
. 1	84262-01	Upper Handle Bracket Assembly	Below		
. 1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	WO 2012-20	
. A/R	3/4-16F	Mesh	Expanded carbon steel	10112	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69812	PO 12088 + PO 12090		
Final Inspection	Drawing 69812			

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Drawing: 84255 Revision 1
Assembly: 84255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	84255-01	Handle Installation			
. 1	84261-01	Handle Bar Assembly	Below		
. 2	84267-01	Bracket	Delrin, 3/4" Sheet	WO2012-15	
. 2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	12033	
. 2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
. 2	AN3-12A	Bolt			
. 4	AN3-11A	Bolt			
. 12	AN960-10	Washer (NAS1149 F0363P)			
. 6	MS21044N3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

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Drawing: 84261 Revision 1
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	36261-01	Handle Bar Assembly			
. 1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube		
. 2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
. 2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
. 2	MS20615-4M3	Monel Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

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Drawing: 84262 Revision 1
Assembly: 84262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
2 Total	84261-01	Handle Bracket Assembly			
. 4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Tube	11049	
. 4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
. 2	36275-02	Support	304 Stainless, 5/16" Rod	11093	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

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Drawing: **70405** **Revision 3**
Assembly: **70405-01** **Lid Step Modification**

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
2 Total	70405-01	Lid Step Modification			
. A/R	70405-03	Tube	4130 Steel, $\frac{3}{4}$ " x 0.035 Sqr. Tube	12045	
. A/R	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	12118	
. 18	CR3213-4-2	Cherry Rivet			

Note: Remainder of assembly listed on drawing 69812

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			

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Drawing: 70411 Revision 0
Assembly: 70411-01 Front End Cutout Modification

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
2 Total	70411-01	Front End Cutout Modification			
. 2	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	12045	
. 1	3/4-16F	Mesh	Expanded carbon steel	10112	

Note: Remainder of assembly listed on drawing 94611 and 94612

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 70411	Rev ϕ		

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TOP GUN COATINGS INC.



PH: (403) 250-5393 FAX: (403) 250-5392

www.topguncoatings.com

DATE: JULY 17, 2012
INVOICE NO: 45600
PO NO: 12088
ATTN: JEFF CLARKE / RICHARD RATHWELL


SHIPPED VIA	TERMS
PICK UP	30 DAYS

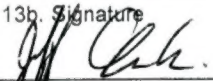
QUANTITY	DESCRIPTION	UNIT PRICE	AMOUNT
	POWDER: SKY WHITE		
1	BASKET W / LID	\$150.00	\$150.00
	WO# 2012-26		
	407 x wide w/outout		
	- No w/w.		
	TOTAL: 2 PIECES		

SUB-TOTAL	\$150.00
GST (5%)	\$7.50
SHIPPING & HANDLING	
TOTAL DUE	\$157.50

Authorized Signature

THANK-YOU FOR YOUR ORDER

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39 th Avenue NE, Calgary, Alberta, T2E 6R7				5. Work Order/Contract/Invoice WO 2012-26	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94510-01	1	94501-01	New
12. Remarks Modified with front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 24 July 2012		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2012-26
6. Item	7. Description Cargo Basket	8. Part Number 94510-01	9. Qty. 1	10. Serial/Batch No. 94501-03	11. Status/Work New
12. Remarks Modified with front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 24 Jan 2013		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

GART RAVCH (US)